

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017109**Date Inspected:** 08-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG segment 12BE, weld No. SEG3002E-253. The welder is identified as #043661. ZPMC QC is identified as Mr.Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

Bay#16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG segment 13AW, weld No. BP3056-001-001. The welder is identified as #201917. ZPMC QC is identified as Mr.Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

SAW in the 1G position for the OBG segment 13AW, weld No. SEG3013AC-003. The welder is identified as #045265. ZPMC QC is identified as Mr.Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

FCAW in the 2G position for the OBG segment 13AW, weld No. LD3031-001-061. The welder is identified as #045143. ZPMC QC is identified as Mr.Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2232-Tc-U5-F.

Bay#14

This QA Inspector observed the following work in progress:

FCAW in the IG position for the OBG segment 13AW, weld No. SEG3013AC-001. The welders are identified as #202122 and #201215. ZPMC QC is identified as Mr.Xia Chen Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2231-B-U3-F.

FCAW in the 2G position for the OBG segment 13AE, weld No. KP3004-001-001. The welder is identified as #066236. ZPMC QC is identified as Mr.Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

SAW in the IG position for the OBG segment 13AW, weld No. SEG3013AC-001. The welders are identified as #250050 and #045270. ZPMC QC is identified as Mr.Xia Chen Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

Magnetic Particle Testing (MPT) for Segment 13AW

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG root pass weld. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designation is as follows

SEG3013AC-001

Ultrasonic Testing (UT) for segment 13CE

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as segment 13CE weld joint.

The welds designation reviewed is as follows:

SEG3011A-007

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

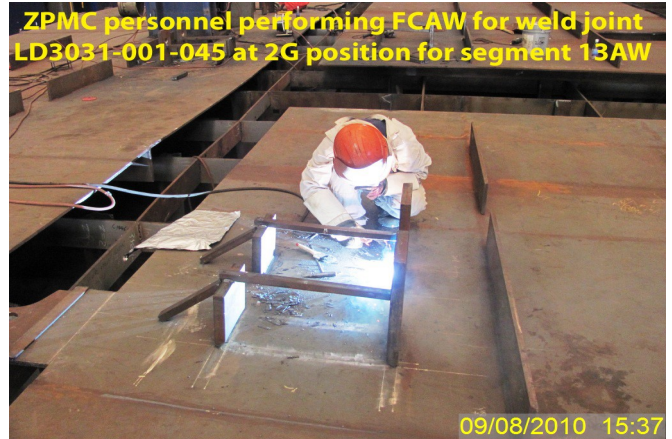
WELDING INSPECTION REPORT

(Continued Page 3 of 3)

ZPMC personnel performing FCAW for weld joint KP3004-001-001 at 2G position for segment 13AE



ZPMC personnel performing FCAW for weld joint LD3031-001-045 at 2G position for segment 13AW



ZPMC personnel performing SAW for splice weld joint SEG3013AC-003 at 1G position on bottom plate of segment 13AW at bay#16



All tack welds cracked due to small length of tack weld at bottom plate BP3095



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer